

Ship 19/09

Dart Aerospace Ltd.

Date: Tuesday, 9/11/2007 10:58:36 AM  
User: Chantal Lavoie

### Process Sheet

Customer : N/A  
Job Number : 34550  
Estimate Number : 13014  
P.O. Number : N/A  
This Issue : 9/11/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : N/A  
Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07-01-15 JLM

Drawing Name : GUIDE TOOL

Part Number : D36571  
Drawing Number : D3657 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : U/R  
Material : N/A  
Due Date : 9/18/2007



Qty: 24 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X01000 6061-T6 Bar .50" x 1.0"



Comment: Qty.: 0.2012 f(s)/Unit Total : 4.8283 f(s)  
6061-T6 Bar .50" x 1.0"  
Batch: M18133

JML 07/09/18 24

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut blank 2.300 " long

JML 07/09/18 24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA669Rev: AA & Dwg D3657 Rev: A

2-Deburr per dwg D3443

JL 07/09/20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 07/09/20

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 07-09-20 21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:58:36 AM  
User: Chantal Lavoie

## Process Sheet

Customer:

Drawing Name: GUIDE TOOL

Job Number: 34550

Part Number: D36571

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*bl 07.09-20*

*(24)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*7/10/24 54*

*24*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: *7/10/15 24 50*

*LE 07.10.15*  
**ENGINEERING  
APPROVAL**

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(24)*  
*07.10.23*

Job Completion



*U 07.10.22*

**ACTIVE RECALL**  
**ACTIVE** *07.09.11* **AUTH** *U*  
**ED** *LE* **DATE** *07.10.24*

**Dart Aerospace Ltd**

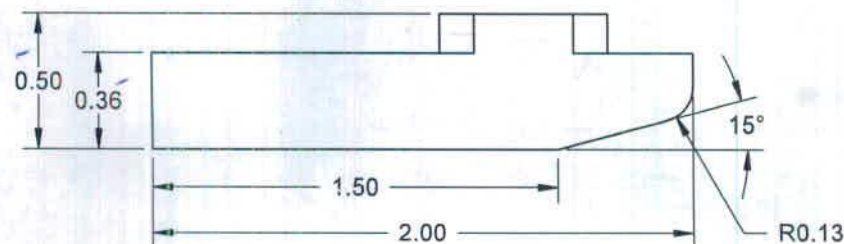
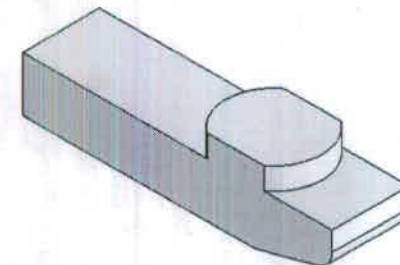
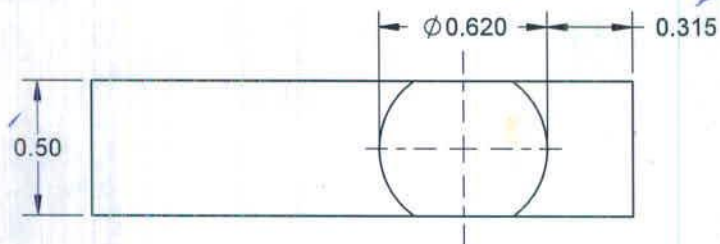
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3657-1 GUIDE TOOL**  
**(WAS GENEVA P/N G12170)**

**PRELIMINARY ISSUE**

07.09.07 16

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/-T6510/-T6511/-T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3657-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs

A	NEW ISSUE; REPLACES G12170	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	CLB	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	CE		
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	EE	D3657	SHEET 1 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.		GUIDE TOOL	3:2
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





